

Work Order ID 82770

82770

Page 1

April-09-12 11:12:31 AM

Item ID: D4445-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cable Guard

Start Date: 4/09/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4445

A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4445

UHMW 1" Blk.

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

⑤
JM/RB
12-4-9

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

CP

Work Order ID 82770***82770***

Page 2

April-09-12 11:12:31 AM

Item ID: D4445-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Guard

Start Date: 4/09/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

120

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo1-Mill as per folio FB072 & dwg D4445,
FOLIO REV: A
DWG REV: A
2-Deburr as required

0.00

0.00

mt 12/04/24

5

6

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

mt 12/04/24

5

6

140

140

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

SL 12-04-25

(5)

Work Order ID 82770***82770***

Page 3

April-09-12 11:12:31 AM

Item ID: D4445-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cable Guard

Start Date: 4/09/12 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/12 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: 207

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

U120427

12/4/30

120427 JB

Picklist Print

April-09-12 11:12:31 AM

Page 1

Work Order ID: 82770

Parent Item: D4445-1

Parent Item Name: Cable Guard

Start Date: 4/09/12

Required Date: 4/11/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 11/10/05 NEW ISSUE JFS VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No				sf	376.7000		3.9909726			
UHMW 1" Black													

Location	Loc Qty	Loc Code
MAT018	35.19999474	
120401	32.1999947	
120972	3	
MAT019	1.5	
118814	1.5	
ST052	340	
121277	20	
121278	320	

M121278

JM/IB
12-4-9

M121278

DART AEROSPACE LTD	Work Order: 82770
Description: CABLE GUARD	Part Number: D4445-1
Inspection Dwg: D4445 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	$\pm .030$	1.750	—		Vern ML-06	
2.04	$\pm .030$	2.040	—		"	
10.23	$\pm .030$	10.230	—		M-type ML-06	
18.41	$\pm .030$	18.410	—			
34.79	$\pm .030$	34.790	—			
51.16	$\pm .030$	51.160	—			
76.60	$\pm .030$	76.60	—			
77.80	$\pm .030$	77.800	—			
1.44	$\pm .030$	1.440	—		Vern ML-06	
1.13	$\pm .030$	1.135	—			
2.94	$\pm .030$	2.938	—			
.95	$\pm .030$.940	—			
.20 x 45°	$\pm .030$.225 x 45°	—			
.78	$\pm .030$.782	—			
.70	$\pm .030$.690	—			
.37	$\pm .030$.370	—			
Ø.437	$\pm .006$	Ø.437	—			
Ø.87	$\pm .030$	Ø.875	—			
.64	$\pm .030$.630	—			
.60	$\pm .030$.590	—			
Ø.75	$\pm .030$.750	—			
Ø.88	$\pm .030$	Ø.875	—			
Ø.85	$\pm .030$	Ø.855	—			
.56	$\pm .030$.560	—			

Measured by: <i>mf</i>
Date: 12/04/24

Audited by: <i>V</i>
Date: 12-04-25

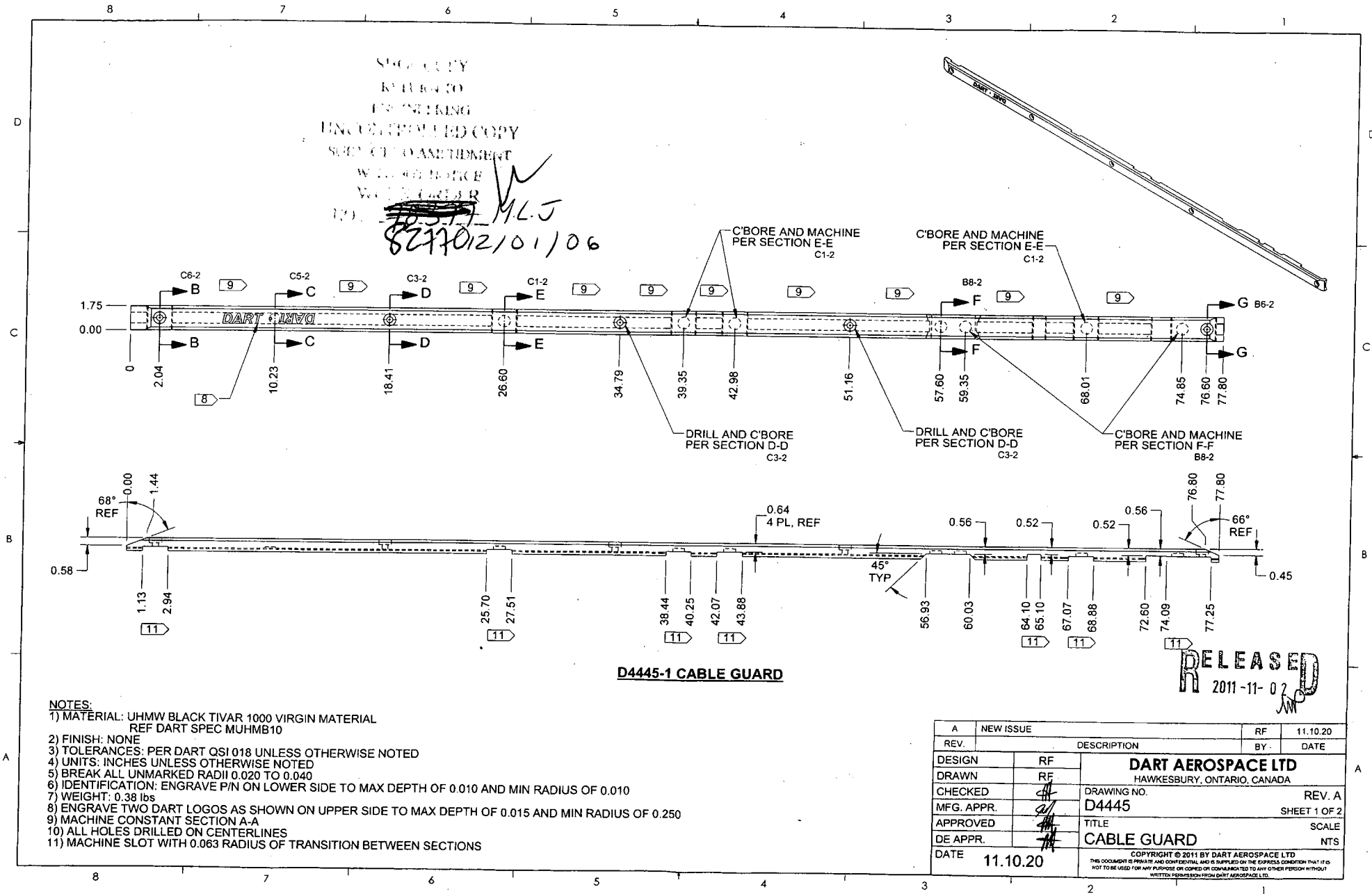
Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

STG COPY
RETURN TO
FOR MARKING
UNCLASSIFIED COPY
SUBJECT TO AMENDMENT
W/ 1000 NOTICE
W/ 1000 R
170

8277012/01/06
M.L.J.



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB10
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED RADII 0.020 TO 0.040
- 6) IDENTIFICATION: ENGRAVE P/N ON LOWER SIDE TO MAX DEPTH OF 0.010 AND MIN RADIUS OF 0.010
- 7) WEIGHT: 0.38 lbs
- 8) ENGRAVE TWO DART LOGOS AS SHOWN ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN RADIUS OF 0.250
- 9) MACHINE CONSTANT SECTION A-A
- 10) ALL HOLES DRILLED ON CENTERLINES
- 11) MACHINE SLOT WITH 0.063 RADIUS OF TRANSITION BETWEEN SECTIONS

A		NEW ISSUE		RF	11.10.20
REV.		DESCRIPTION		BY -	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	RF				
CHECKED	RF	DRAWING NO.		REV. A	
MFG. APPR.	RF	D4445		SHEET 1 OF 2	
APPROVED	RF	TITLE		SCALE	
DE APPR.	RF	CABLE GUARD		NTS	
DATE		COPYRIGHT © 2011 BY DART AEROSPACE LTD			
11.10.20		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

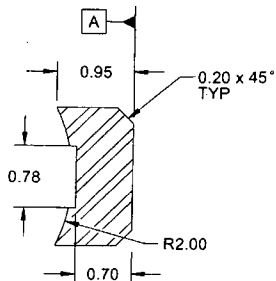
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

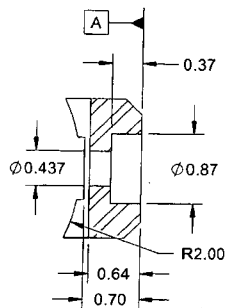
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

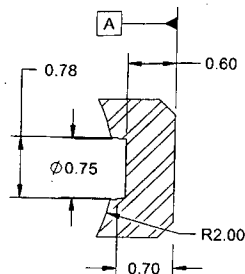
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82720a



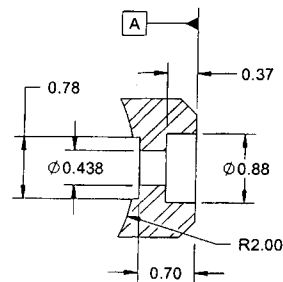
SECTION A-A C1-1
SCALE 3.5X TO C8-1



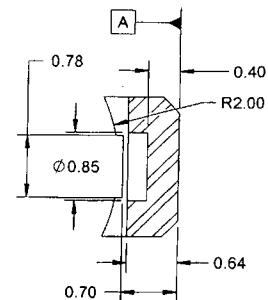
SECTION B-B C8-1
SCALE 3.5X



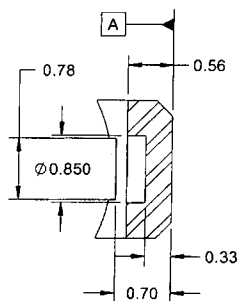
SECTION C-C C7-1
SCALE 3.5X



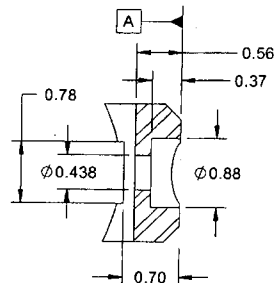
SECTION D-D C3-1
SCALE 3.5X C4-1
3 PL C6-1



SECTION E-E C2-1
SCALE 3.5X C4-1
4 PL C5-1
C6-1



SECTION F-F C1-1
SCALE 3.5X C3-1
3 PL



SECTION G-G C1-1
SCALE 3.5X

RELEASED
2011-11-02

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4445	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CABLE GUARD	NTS
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries